

Work Order ID 128107

Wednesday, January 07, 2015 8:07:25 AM

128107

Page 2

Item ID: 647.9701 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Sub Assembly
 Start Date: 1/7/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 1/7/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

10X
 DAS
 28
 9-89
 JAN 08 2015
 MLJ 15-01-09
 MF
 15-01-09.

Picklist Print

Wednesday, January 07, 2015 8:07:30 AM

Page 1

Work Order ID: 128107

128107

Parent Item: 647.9701

647 9701

Parent Item Name: Lower Cutter Sub Assembly

Start Date: 1/7/2015

Required Date: 1/7/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 13-03-21 JLM VERIFIED BY:DD IPP
REV:B 14.08.27 AS PER REVA2 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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647.9710		Manufactured	No				Each	14.0000		10		DAS 41 9-89	15-1-7
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647 9710

Lower Body

Location	Loc Qty	Loc Code
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MF	14	
121355	14	

MS27039-08-19		Purchased	No				Each	407.0000		60		DAS 41 9-89	15-1-7
---------------	--	-----------	----	--	--	--	------	----------	--	----	--	-------------------	--------

MS27039-08-19

Screw

Location	Loc Qty	Loc Code
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ST273A	407	
m130505	407	

NAS1149FN832P		Purchased	No				Each	5,672.000		120		DAS 41 9-89	15-1-7
---------------	--	-----------	----	--	--	--	------	-----------	--	-----	--	-------------------	--------

NAS1149FN832P

Washer

Location	Loc Qty	Loc Code
----------	---------	----------

ST260a	3600	
125268	3600	
st268	2072	
M130388	2072	

10

60

60 + 2 scrap

120

Picklist Print

Page 2

Wednesday, January 07, 2015 8:07:30 AM

Work Order ID: 128107

128107

Parent Item: 647.9701

647 9701

Parent Item Name: Lower Cutter Sub Assembly

Start Date: 1/7/2015

Required Date: 1/7/2015

Start Qty: 10.00

Required Qty: 10.00

MS21042L08

Purchased

No

Each

1,197.000

60

DAS

MS21042L 08

41
9-89

15-1-7

Nut

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST304

1096

123900

16

m128401

480

m130325

600

60 + 2 scrap

646.9711

Manufactured

No

Each

46.0000

20

DAS
41
9-89

646 9711

15-1-7

Blade

Location

Loc Qty

Loc Code

MF1

46

126803

46

20

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04646

SHEET 1 OF 1

DWG NO. 647.9700

REV: A

PREPARED BY

D. MEJIA

DATE: 07/25/14

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR

MFG

QC

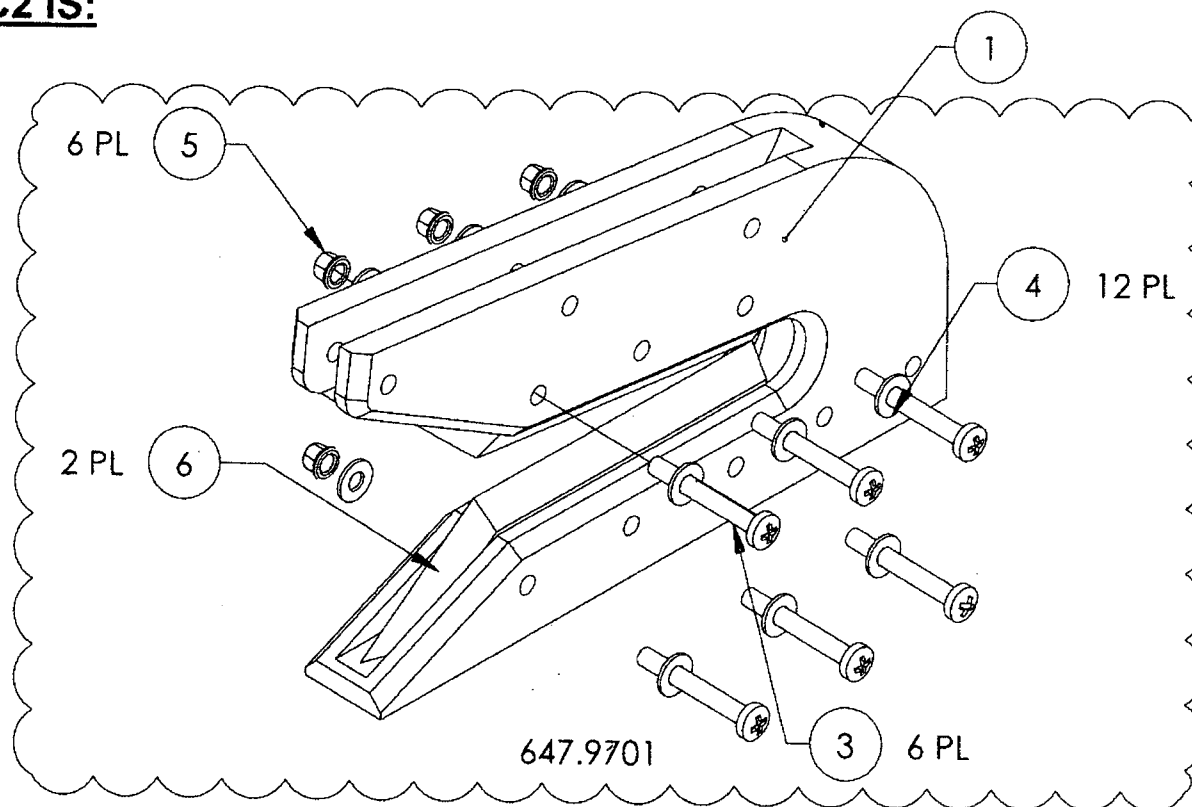
EFF.

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: REVISED BOM.

SHEET 1, ZONE C2 IS:



SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12-8107
MCS
1501-07

SHEET 1, BOM IS:

5	R	601.1541	6	LOCKNUT	MS21042L08	
4	R	601.2764	12	WASHER	NAS1149FN832P	
3	R	601.2765	6	SCREW	MS27039-0819	
F/N	TC	PART NUMBER	.9701	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY			
DOCUMENTS EFFECTED:				CHANGE CATEGORY		
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM				DER REVIEW REQUIRED		
				☐ MAJOR ☒ MINOR ☐ YES ☒ NO		

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

03933

SHEET 1 OF 1

DWG NO. 647.9700

REV: A

PREPARED BY B. PETERS

DATE: 06/14/13

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSYS

APPROVED BY: ENGR

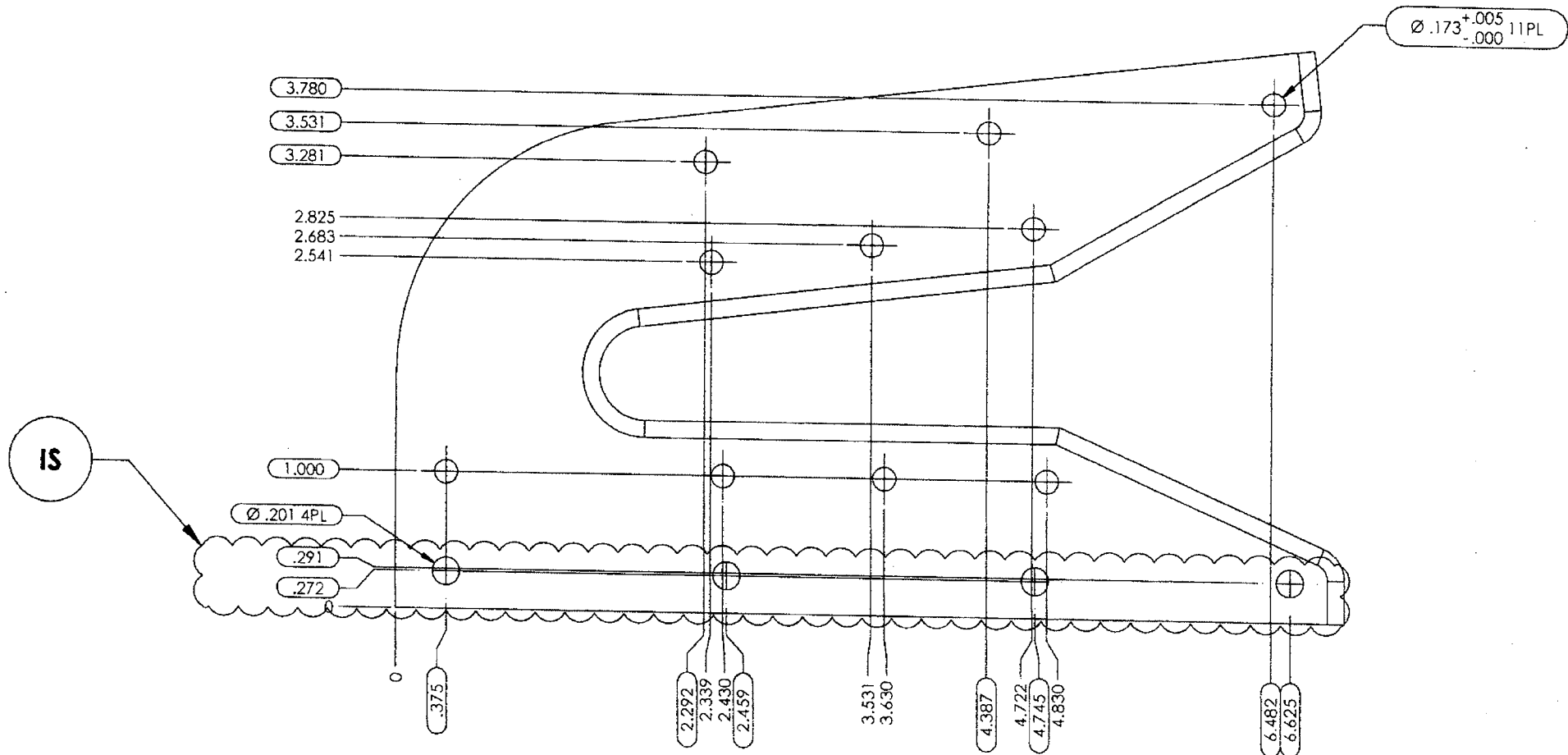
MFG

QC

EFF. CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: CORRECTED DIMENSIONAL ERROR.



SHEET 7, ZONE C1 IS:

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

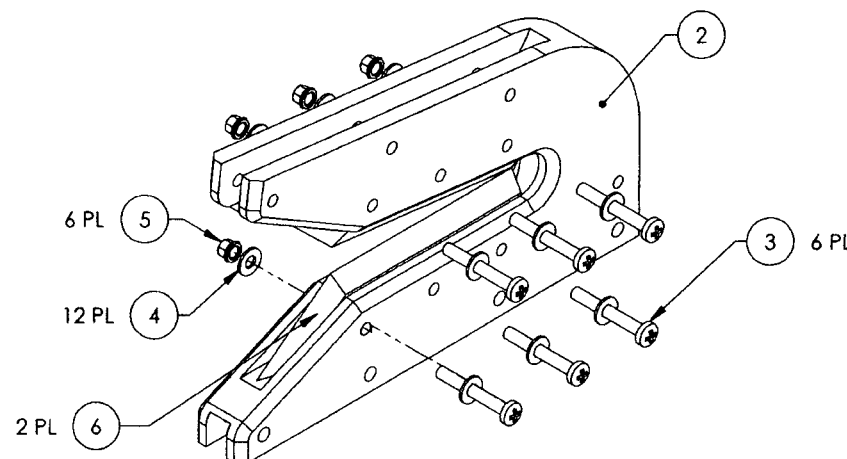
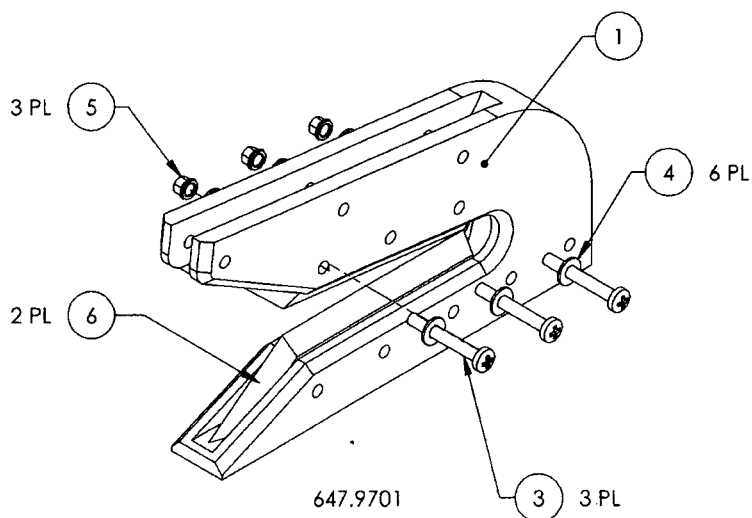
☐ YES ☒ NO

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NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX.
- 4 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED.
- 5 IDENTIFY IAW MPP-120.
- 6 APPLY F/N 7 AS REQUIRED TO ALL FAYING SURFACES OF F/N 6 UPON ASSEMBLY.
- 7 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE.
- 8 DIMENSION SHOWN IS FOR INSPECTION AFTER FINISH.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE RELEASE: PR1		
P/C	INITIAL RELEASE	04-26-10	P. BRAVO
A	INCORPORATED ECH 03027 & 03559	04-11-13	P. BRAVO



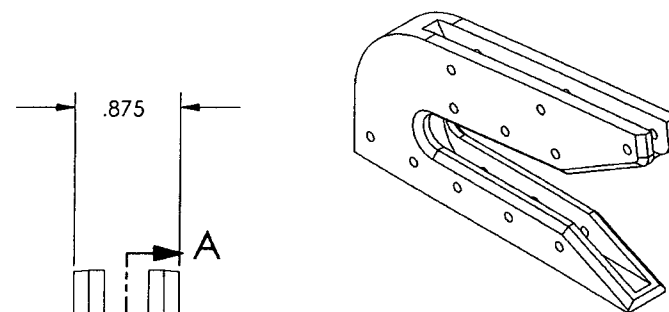
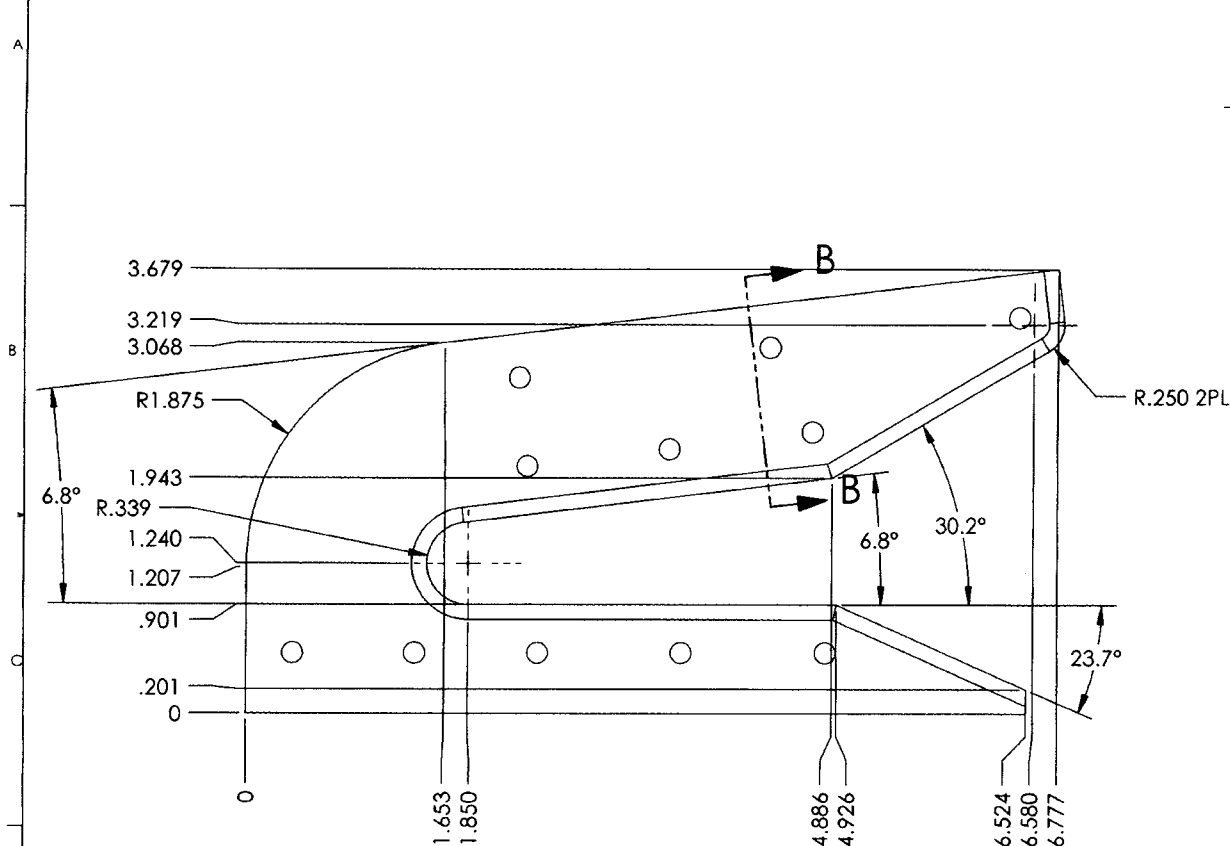
647.9702

UNINCORPORATED ECN(s)

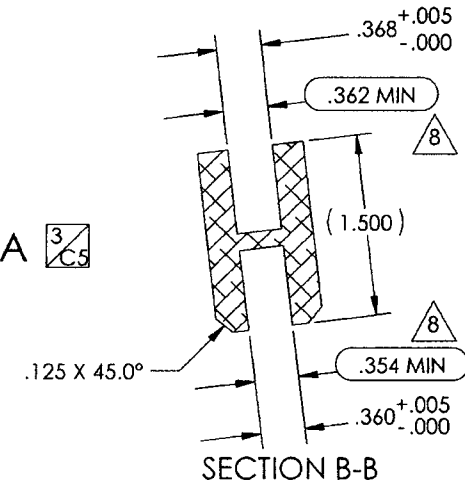
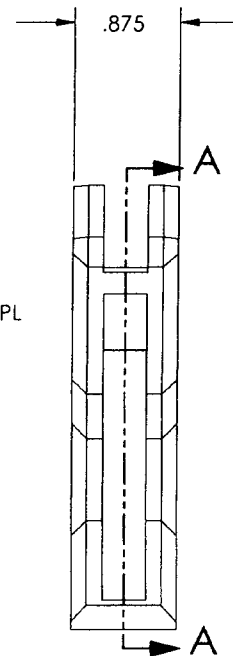
03433, 0410416

A/R	A/R	7	601.2764	RTV	LOCTITE 598	
2	2	6	646.9711	BLADE		
6	3	5	601.1541	LOCKNUT	MS21042L08	
12	6	4	601.2764	WASHER	NAS1149FN832P	
6	3	3	601.2765	SCREW	MS27039-0819	
1		2	647.9711	UPPER BODY		1
	1	1	647.9710	LOWER BODY		1
			647.9702	UPPER CUTTER ASSY		
			647.9701	LOWER CUTTER ASSY		
.9702	.9701	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY			PARTS LIST			
NEXT ASSY (S)			ORIGINAL DATE	APICAL INDUSTRIES		
647.9200			DRAWN BY	2608 TEMPLE HEIGHTS DR		
			CHECKER	OCEANSIDE, CA. 92056-3512 (760)724-5300		
			A. OLAN	CUTTER SUB ASSYS		
			P. BRAVO			
			CONTRACT NO.			
			UNLESS OTHERWISE SPECIFIED			
			DIMENSIONS ARE IN INCHES			
			TOLERANCES ARE:			
			2 PLACE DECIMALS ±.003			
			3 PLACE DECIMALS ±.010			
			ANGLES ±.5°			
			SCALE: NONE			
			SHEET 1 OF 7			

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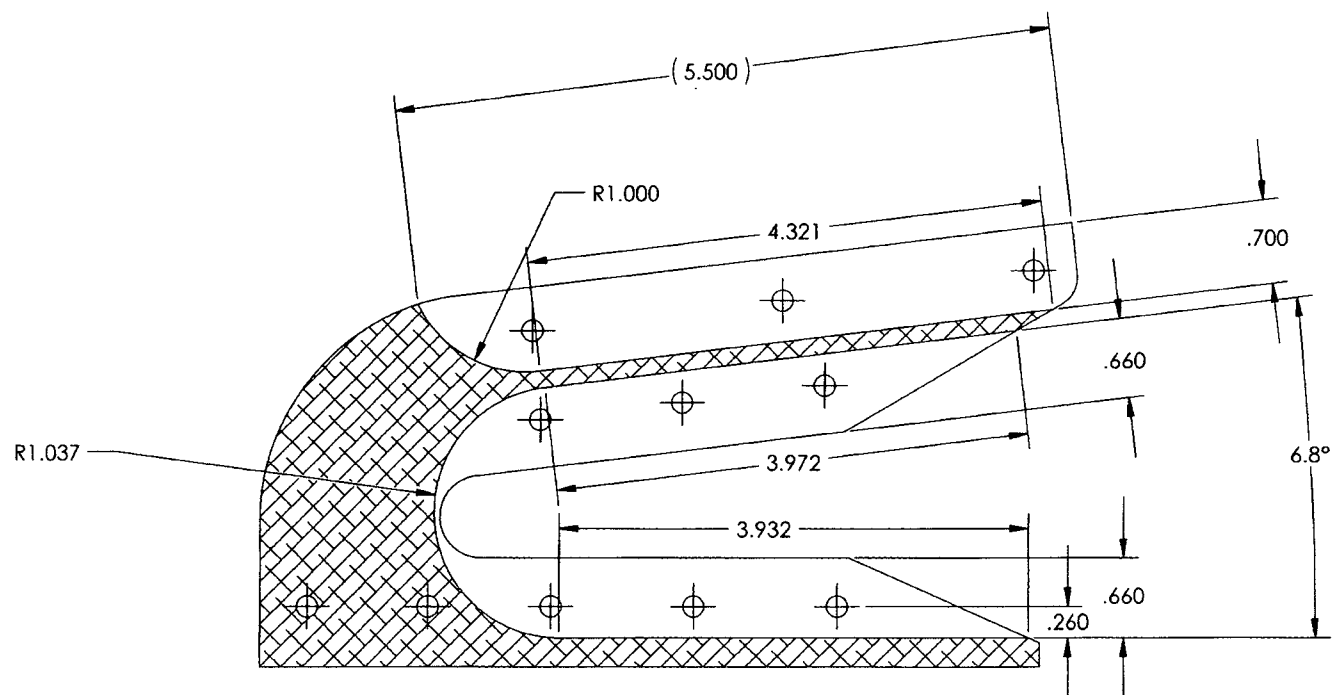


647.9710



ORIGINAL DATE 04-26-10		APICAL INDUSTRIES	
DRAWN BY A. QUAN	CHECKED BY P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL DATE 04-26-10	CONTRACT NO.	CUTTER SUB ASSYS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SHEET B 07M26	REV A
SCALE NONE		SHEET 2 OF 7	

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SECTION A-A 2/B6

ORIGINAL DATE 10/24/77 06:26:10		APICAL INDUSTRIES	
DRAWN BY A. QUAN		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAYO			
DATE 10/24/77			
CONTRACT NO.		CUTTER SUB ASSYS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°			
SHEET: B	CAGE CODE 07M26	DWG. NO. 647.9700	REV. A
SCALE: NONE		SHEET 3 OF 7	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

CUTTER SUB ASSYS

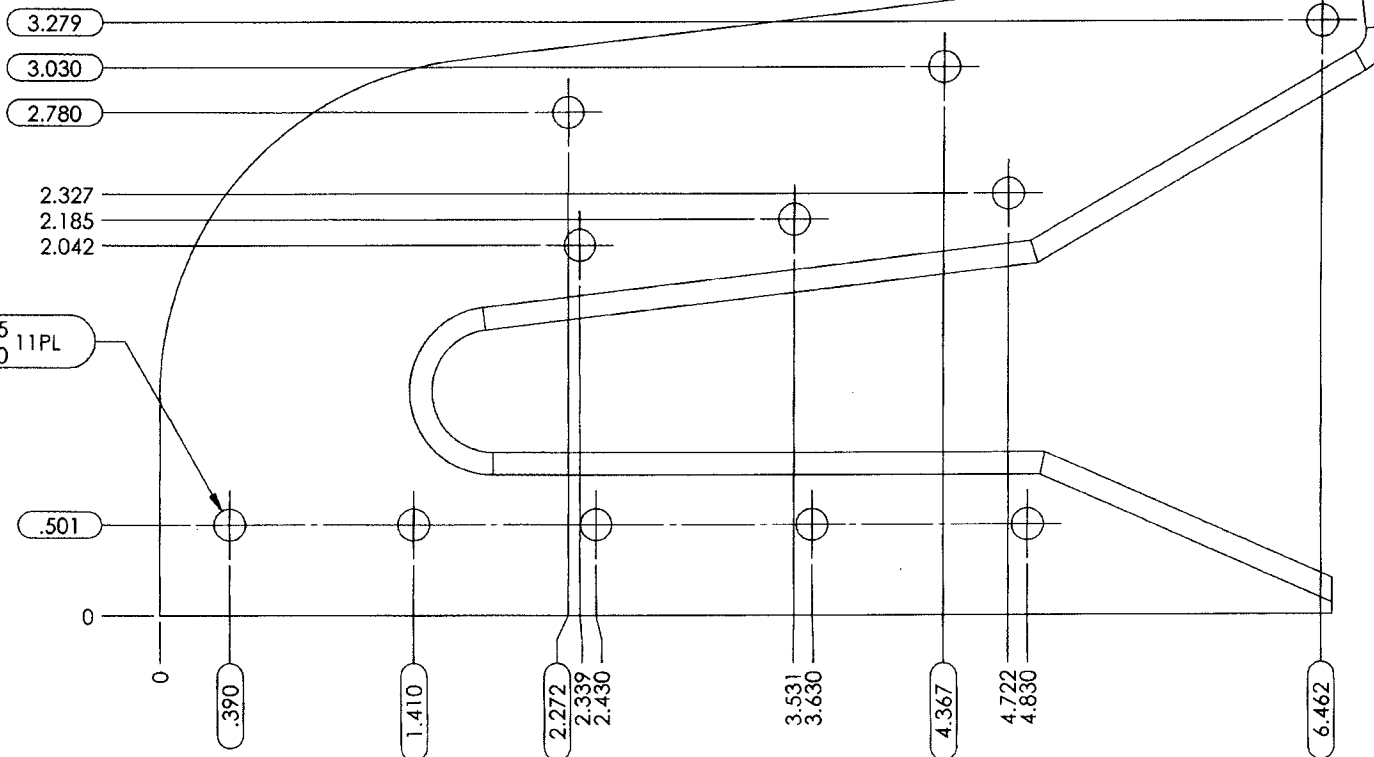
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A

B

C

D



ORIGINAL DATE: 04-28-10
DRAWN BY: J. QUAN
CHECKED BY: P. BRAYD
DRAWING APPROVAL: P. BRAYD
DESIGNED BY: J. QUAN
CONTRACT NO:

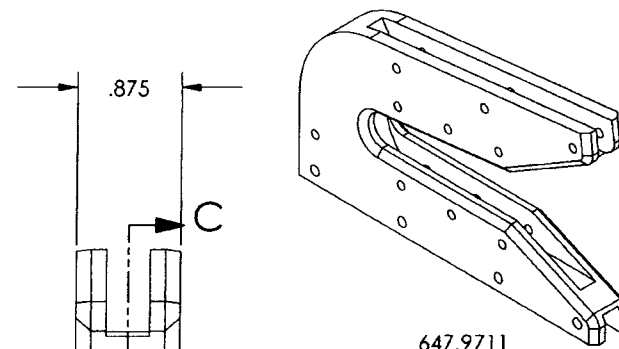
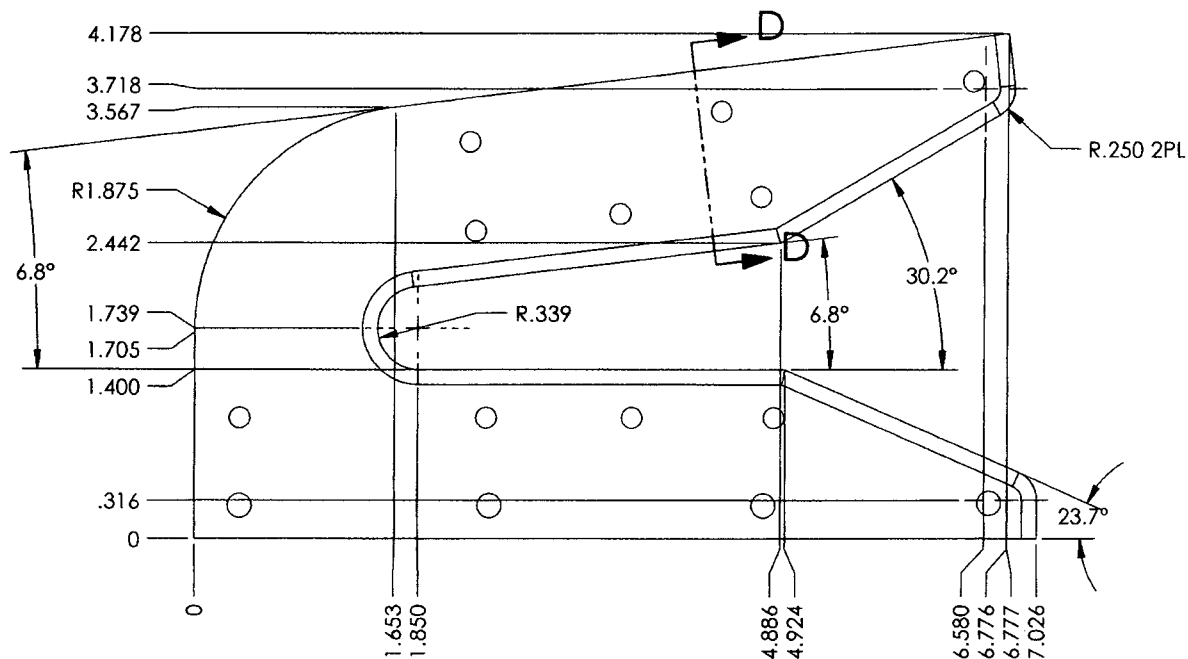
APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

CUTTER SUB ASSYS

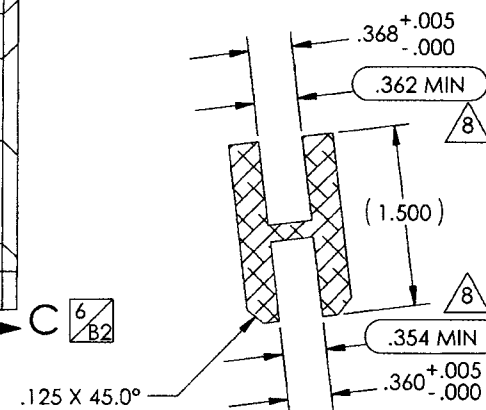
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
1. PLACE DECIMALS 2 DIG
2. PLACE DECIMALS 2 DIG
3. PLACE DECIMALS 2 DIG
ANGLES ± .5°

SHEET: 07/02/10
CAGE CODE: 647.9700
DWG. NO.: 647.9700
REV: A
SCALE: NONE
SHEET: 4 OF 7

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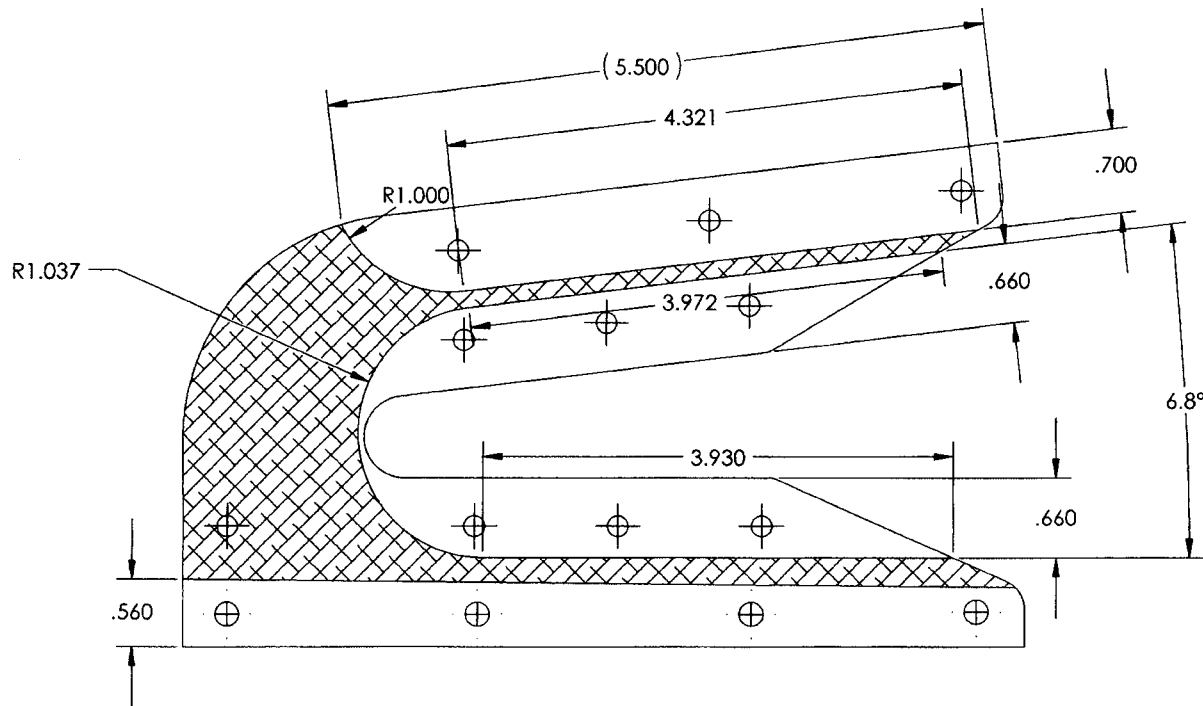
647.9711



SECTION D-D

ORIGINAL DATE: 04-28-10		APICAL INDUSTRIES	
DRAWN BY: A. QUINN		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: D. BRAYO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: P. BRAYO		CUTTER SUB ASSYS	
DESIGNED BY: P. BRAYO		DWG. NO. 647.9700	
CONTRACT NO.		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET 5 OF 7	

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SECTION C-C

5
86

ORIGINAL DATE (1/23/2010) (2/26/10)		APICAL INDUSTRIES	
DRAWN BY A. QUAN		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		CUTTER SUB ASSYS	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SHEET 8	REV A
		DWG. NO. 647.9700	
		SCALE NONE	SHEET 6 OF 7

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